

Date: Friday, 9/29/2006 10:43:23 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP SPACER
Job Number	: 28791C	Part Number	: D2322
Estimate Number	: 10354	Drawing Number	: D2322 REV C
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 9/29/2006 S.O. No. : N/A	Drawing Revision	: C
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 10/10/2006 Qty: 20 Um: Each
Previous Run	: 27756C		
Written By	: <i>JLM</i>		
Checked & Approved By	: <i>JLM 09/29</i>		
Comment	: Est Rev:A New Issue 05-11-07 JLM Est Rev:B Now on Waterjet 06-07-03 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S040	2024-T3 .040 sheet	
		Comment: Qty.: 0.2132 sf(s)/Unit Total : 4.2630 sf(s) Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick (M2024T3S.040) Identify as D2322 Batch: M102448	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D2322 Dwg Rev: <i>C</i> Prog Rev: <i>C</i>	<i>SAD 06:10:29 (20)</i>
		2-Deburr if necessary	<i>SAD 06:10:30 (20)</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>SAD 06:10:29 (20)</i>
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<i>Job 10:30 M06/10/20 (20)</i>
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE Form as per Dwg D2322	<i>SB 06/11/06 (20)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/11/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/11/06 (20)

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



FC

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

06/11/10 x 20

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/14/13 (20)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 37

06/14/13 (20)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/13 (20)

Job Completion



C Locel W/13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	28791C
Description: Step Spacer	Part Number:	D2322
Inspection Dwg: D2322	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	SAN	Audited by:	AB	Prototype Approval:	N/A
Date:	06.10.28	Date:	06.10.30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.10.12	New Issue P/O D2582	KJ/JLM	SJM

DESIGN BY	DRAWN BY	DART AEROSPACE LTD
CHEKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE		REV. C
98.09.29		SHEET 1 OF 1
		SCALE



DART

RELEASED
18.10.88 DS

UNDER REVIEW

0.128 (TYP 12 PLACES)

~~DESIGN OK, BUT CHECK WITH
CFS BEFORE MANUFACTURE~~

OK 6/14/94 AF

0.125
(TYP 4 PLACES)
KE-1005-06

MATERIAL: 2024-T3 (QD-A-250/5) 0.040 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28-971C

